

Work Order ID 128240

128240

Page 1

Tuesday, January 13, 2015 1:33:27 PM

Item ID: D4005-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Forward Floor Gutter
Start Date: 1/13/2015 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 1/20/2015 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: MLS Date: 15-01-14 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4005	B								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg (D4005-13)								
60061.040	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2-Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(4) _____ D-15/01/26
(4) _____ D-15/01/26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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DQA: _____ Date: _____



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 Revision ID: Stop ***NS2***
 Item Name: Forward Floor Gutter
 Start Date: 1/13/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/20/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00				4	0	15-2-6	Doc [Signature]
150	HandFinish	0.00							
Hand Finishing	Memo								
155	QC7-Inspect Chemical Conversion Coat	0.00				4	0	15-2-11	DAS 34 9.89
155	QC	0.00							
Quality Control	Memo								
160	Gloss Grey (4.3.5.15) per QSI 005 4.3	0.00				4	0	15-2-11	DAS 34 9.89
160	Powdercoat	0.00							
Powder Coating	Memo								
	Start Time: 2:30								
	Oven Temperature: 320								
	Finish Time: 3:00								

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Training									
Transport									
Unapproved									

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Work Order ID 128240

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128240

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 Start Date: 1/13/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/20/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									DAS
QC	Memo	0.00							38
Quality Control									FEB 12 2015
190	Identify as per dwg & Stock Location: St234A	0.00							
190									DAS
Packaging	Memo	0.00							06
Packaging									9-89
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

15.2-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Work Order ID: 128240

128240

Parent Item: D4005-041

D4005-041

Parent Item Name: Forward Floor Gutter

Start Date: 1/13/2015

Required Date: 1/20/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.01.21 new issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC IPP Rev:C 12.03.07 as
per dwg rev.b DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

100

sf

64.7501

0.42

2

M6061T6S 040

6061-T6 .040 Sheet

DL 15/01/26

Location

Loc Qty

Loc Code

MAT021

64.7501

m13031

32

m130585

32.7501

2.1388

D4003-13

Manufactured

No

141

Each

8.0000

1

4

D4003-13

Fwd Fuel Gutter Line

DL 15-24

Location

Loc Qty

Loc Code

ST077

5

100271

3

127778

2

WA002

3

122405

2

98609

1

128369 x 3

3

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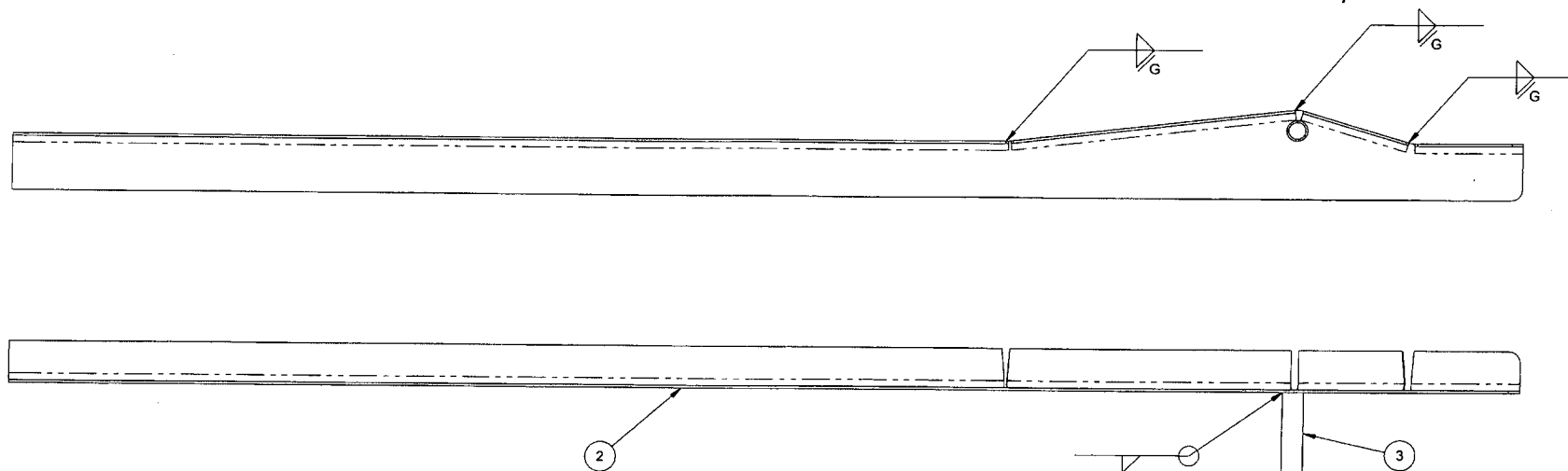
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4005-041	FORWARD FLOOR GUTTER	JCA-M47-2-22
2	1	D4005-13	ANGLE	
3	1	D4003-13	TUBE	

SHOWN COPY
REFLECTS
UNCONTROLLED COPY
SUBJECT TO
REVISIONS
DATE 128240 MLJ
1501-14



D4005-041 FORWARD FLOOR GUTTER

RELEASED
2012-03-02
JMP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.22 lbs
- 8) WELD PER DART QSI 004

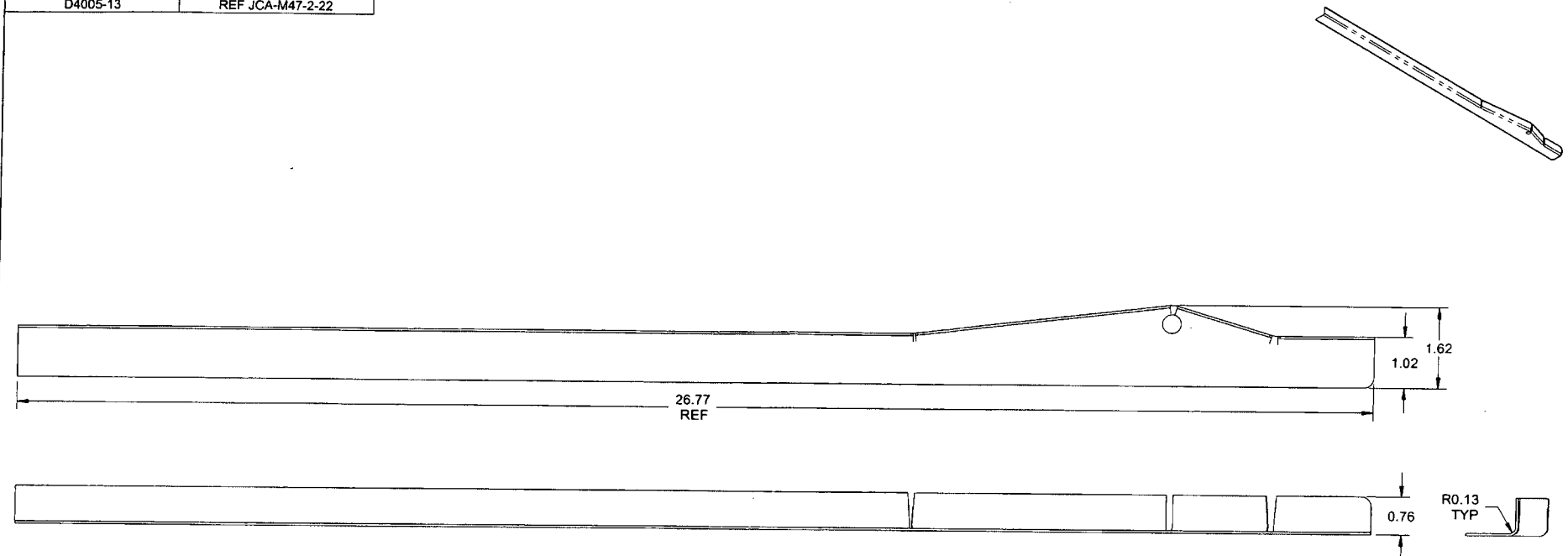
B	ADD TOOLING HOLE, ZN C7-3	HS	11.06.06
A	NEW ISSUE	HS	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4005
REV. B
SHEET 1 OF 15
TITLE RESTRAINT
SCALE NTS

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4005-13	REF JCA-M47-2-22



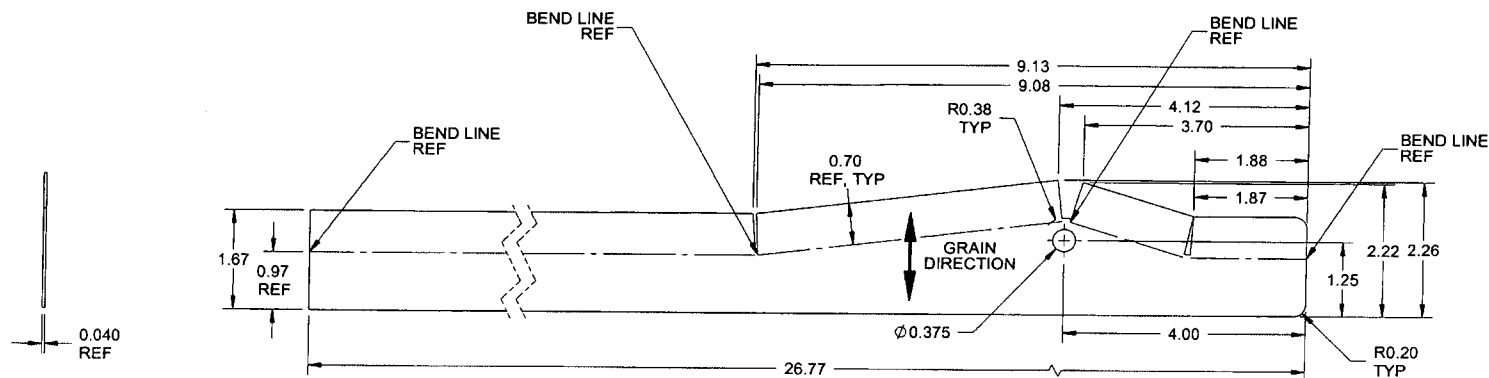
D4005-13 ANGLE

RELEASED
2012-03-07
JND

NOTES:

- 1) MATERIAL: MADE FROM D4005-13F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4005	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		RESTRAINT	NTS
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D4005-13F FLAT PATTERN

NOTES:

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.21 lbs

RELEASED
2012-03-02
NW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4005	REV. B
MFG. APPR.		SHEET 15 OF 15	
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DE APPR.		NTS	
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